

Work Order ID 83840

83840

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Thursday, April 26, 2012 1:08:48 PM

Item ID: D4577-3 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Middle Access Panel
 Start Date: 4/26/2012 Start Qty: 4.00 *4* Cust Item ID:
 Required Date: 5/3/2012 Req'd Qty: 4.00 *4* Customer:
 Reference:

Approvals: Process Plan: mf Date: 12-04-26 Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr								
D4577	B								

100 0.00

100 FLOW WATER JET

Waterjet Memo 0.00

FLOW CNC Waterjet 1-Cut D4577-6 as per Dwg

6061-129 Dwg Rev: B

Prog Rev: B

2-Deburr if necessary

110 QC2- Inspect parts off machine FAI/FAIB 0.00

110

QC Memo 0.00

Quality Control

120 QC8- Inspect parts - second check 0.00

120

QC Memo 0.00

Quality Control

Schedule

40

12-4-27

12-4-27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	Chemical Conversion Coat per QSI005 4.1	0.00							
150									
HandFinish	Memo	0.00							
Hand Finishing									
160	QC7-Inspect Chemical Conversion Coat	0.00							
160									
QC	Memo	0.00							
Quality Control									
170	Gloss Grey (4.3.5.15) per QSI 005 4.3	0.00							
170									
Powdercoat	Memo	0.00							
Powder Coating	***TOP SIDE ONLY***								
	START TIME: 1:50								
	OVEN TEMPERATURE: 320 °F								
	FINISH TIME: 2:20								

M 118533

(4) NG 12-4-30

4X M-L 12/05/08

4X M-L 12/05/08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180	QC3- Inspect Part Finish	0.00				4	0	12/5/9	
180									
QC	Memo	0.00							
Quality Control									
190	Identify as per dwg & Stock Location: 237A	0.00				4		12/5/9	
190									
Packaging	Memo	0.00							
Packaging									
200	QC21- Final Inspection - Work Order Release	0.00						12/5/9	
200									
QC	Memo	0.00							
Quality Control									

MF
12-05-09

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

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Parent Item: D4577-3

Parent Item Name: Middle Access Panel

Start Date: 4/26/2012

Required Date: 5/3/2012

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP REV:A 12.03.08 NEW ISSUE DD VERF:EC
DWG REV.B DD VERF:EC

IPP REV:B 12.04.25 AS PER

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M6061T6S.125

Purchased

No

100

sf

113.1500

1.022

4.3031579

6061-T6 .125 Sheet

B12-4-27

Location

Loc Qty

Loc Code

MAT021

113.15

120218

3.21

121473

109.94

121473

(4)

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8

7

6

5

4

3

2

1

D

C

B

A

0.125
REF

R2.25
TYP

11.70

10.50

9.79

100°

4.33
PITCH
REF

0.63
REF

Ø0.206
8 PL, EQUALLY SPACED

2

D4577-3 MIDDLE ACCESS PANEL

NOTES:

- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET, 0.125 THK
PER QQ-A-250/11 OR AMS-QQ-A-250/11
OR AMS 4025 OR AMS 4027 OR ASTM B209
REF DART SPEC M6061T6S.125
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "ANSI 61 GREY" (4.3.5.15) PER DART QSI 005 4.3 TOP SIDE ONLY
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.32 lbs

83840

RELEASED
2012-04-24
JAY

DESIGN	DC	DART AEROSPACE LTD	
DRAWN	DC	HAWKESBURY, ONTARIO, CANADA	
CHECKED	EB	DRAWING NO. D4577	REV. B
MFG. APPR.	EB	SHEET 3 OF 4	
APPROVED	140	TITLE	SCALE
DE APPR.	JAY	ACCESS PANEL	NTS
DATE	12.03.30	COPYRIGHT © 2012 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

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